

Work Order ID 139197

139197

Thursday, December 03, 2015 1:06:41 PM

Page 1

Item ID: PB67-43001-239W

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Square Tube Weldment

Start Date: 11/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/11/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MCS Date: DEC 03 2015

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-09	D

110 239 Weld per dwg A/R Aluminum rod Batch: 13/560

110

Large Fab

Large Fab

Memo

0.00

- 1- Cut to length as per dwg
- 2- Make a chamfer on both ends of tube
- 3- Drill holes as per dwg use drill jig DT10022
- 4- Make a chamfer on both side of the 4 holes
- 7- Deburr

4 **DAS**
24
9-89
FEB 12 2016

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Quality Control

~~CONVENTIONAL MILLING MACHINE~~

Memo

0.00

4 **DAS**
43
9-89
FEB 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 16.6%;">Skid-tube ☐</td> <td style="width: 16.6%;">Cross tube ☐</td> <td style="width: 16.6%;">Water Jet ☐</td> <td style="width: 16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
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Page 2

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Setup Start

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Stop

NS2

Start Date: 11/16/2015 Start Qty: 6.00

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Cust Item ID:

Required Date: 12/11/2015 Req'd Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC5- Inspect part completeness to step on W/O	0.00							
125						<u>4x</u>		DAS 43	FEB 12 2016
QC	Memo	0.00						9-89	
Quality Control									
130	Identify as per dwg & Stock Location: <u>WWA 04</u>	0.00							
130						<u>4x</u>		DAS 43	FEB 12 2016
Packaging	Memo	0.00						9-89	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Signature 20160212

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : ☐							

Picklist Print

Thursday, December 03, 2015 1:06:45 PM

Page 1

Work Order ID: 139197

139197

Parent Item: PB67-43001-239W

PR67-43001-239W

Parent Item Name: Square Tube Weldment

Start Date: 11/16/2015

Required Date: 12/11/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 15.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.125		Purchased	No				f	359.8849		11.05263			
M6061T6TS1 000W 125												FEB 12 2016	DAS 24 9-89
6061T6 SQ TUBE 1.00 x 1.00 x .125w													

Location	Loc Qty	Loc Code
MAT	82.0469	
m132577	82.0469	
MAT028	277.838	
m128034	209.755	
m128248	68.083	

PB67-43001-223

Manufactured No

PR67-43001-223

Square Cap

Location	Loc Qty	Loc Code
Mezz2	10	
133770	10	
	Each	19.0000

PB67-43001-225

Manufactured No

PR67-43001-225

Bushing

Location	Loc Qty	Loc Code
Mezz2	19	
112762	7	
135083	12	

**

**

**

~~7.38~~ 7.38
6

4
24

4
12

FEB 12 2016

FEB 12 2016

DAS 24 9-89

DAS 24 9-89

DQA: _____ Date: _____



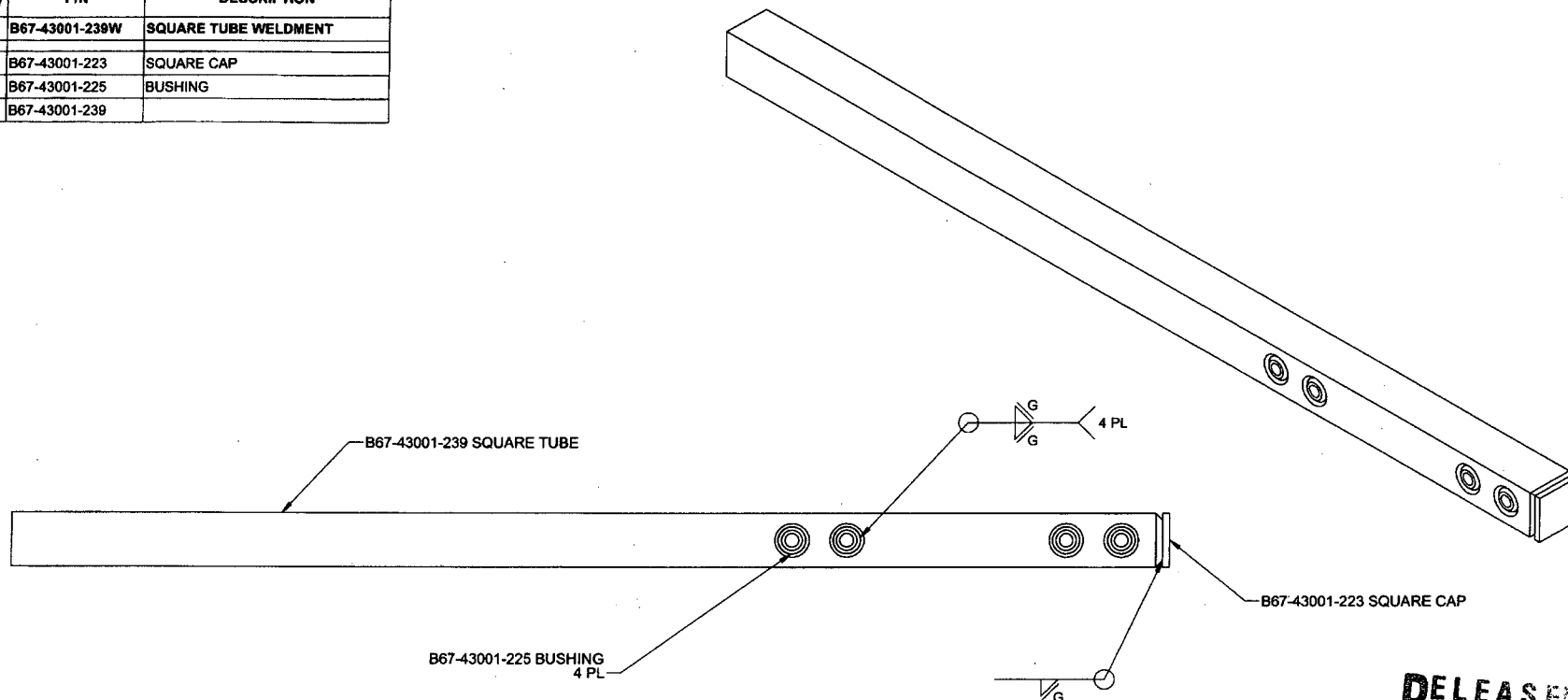
WORK ORDER NON-CONFORMANCE / UPDATE

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ITEM	QTY -239W	P/N	DESCRIPTION
	X	B67-43001-239W	SQUARE TUBE WELDMENT
1	1	B67-43001-223	SQUARE CAP
2	4	B67-43001-225	BUSHING
3	1	B67-43001-239	



RELEASED
2014-12-08
W

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.94-lbs
- 8) WELDING: PER DART QSI 004

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

139197 NLS
15-12-03

REV.	DESCRIPTION	BY	DATE
D	ADD -239W WELDMENT, REMOVE CHAMFER (ZN C4-2). REASON: TO FACILITATE MANUFACTURING	DB	14.07.22
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 21 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.19
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-239 REV. D SQUARE TUBE SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	14.07.22		

0.13 X 45° CHAMFER

Ø0.500 THRU
Ø0.625 X 45° CHAMFER
TYP BOTH SIDES
4 PL

0.750

1.750

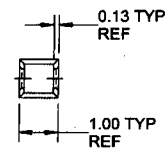
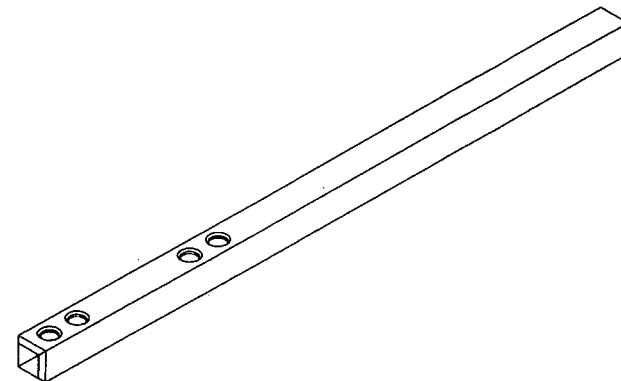
5.750

6.750

0.500

21.00

B67-43001-239 SQUARE TUBE



RELEASED
2014-12-08

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.87 lbs

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	QB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	6	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	B67-43001-239	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	